

Date: Friday, 1/25/2008 11:00:43 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 407 FWD X-TUBE
 Job Number : 37005
 Estimate Number : 12348
 P.O. Number :
 This Issue : 1/25/2008 S.O. No. :
 Prsht Rev. : NC Part Number : D407667105 TRN
 First Issue : / / Type : LANDING GEAR Drawing Number : D407-667-145 REV B
 Previous Run : 37004 Drawing Revision : B
 Material :
 Due Date : 3/10/2008 Qty: 1 Um: Each
 Written By :
 Checked & Approved By :
 Comment : Est Rev: 05.09.01 Add holes for compatibility with Bell
 Skidtubes KJ/JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D407-667-105 CHG002

2.0

D6010115

Crosstube Material



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part number Description Batch

1 D6010-115 Crosstube 332308

Check OD = 2.250"; ID = 1.610"

BG 05.02.27

①

3.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Fill tube with sand & install plugs DT8673on both ends as per Folio FA249

2-Turn first side as per Folio FA249

3-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D407-667-145.

BG 05.03.01

4.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

BG 05.03.01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: 407 FWD X-TUBE

Job Number: 37005

Part Number: D407667105

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Turn second side as per Folio FA249

2-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D407-667-145.

3-Remove sand and plugs

4-Scribe part # and batch # using vibrating stylus as per Dwg D206-667-145

Inside of Cuff(Donot engrave on outside of tube)

SC 08-03-01

(1)

6.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

SC 08-03-01

(1)

7.0

QC8

SECOND CHECK



Comment: SECOND CHECK

9ml 08/03/03

(1)

8.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

AWM 8-3-11

1-Polish entire outside surface of crosstube

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/03/11 (x2)

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

JB 8-3-11

11.0

BENDING

BENDING MACHINE



Comment: BENDING MACHINE

Bend tube as per Dwg D407-667-145 using CNC bender program 407-fw and Folio FT016

ED + STK

DD 8-4-2

W/O:		WORK ORDER CHANGES					
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Process Sheet

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Drawing Name: 407 FWD X-TUBE

Job Number: 37005

Part Number: D407667105

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

13.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

N/A *stacking or Turned only*

1-Drill pilot holes in tube using drill Jig DT8541 & DT8542 as per Dwg D407-667-145. Drill all (3) top holes.

2-Drill and Ream all holes in tube to finish size using drill Jig DT8541 & DT8542 as per Dwg D407-667-145
Check dimensions between holes on all four sides.

3-Flip tube and switch drilling Jigs from right to left, left to right. Locate Jigs off existing holes using "T" pins.

4-Drill pilot holes using drill Jig DT8541 & DT8542 as per Dwg 407-667-145. Drill only the top (2) holes.

5-Drill & ream the top (2) holes to finish size using drill Jig DT8541 & DT8542 as per Dwg D407-667-145

6-Drill Fwd rivet holes using drill Jig DT8787FWD as per Dwg D206-667-145. Note: Fwd side has 3x top holes.

7-Drill Aft rivet holes using drill Jig DT8787AFT as per Dwg D407-667-145.

8-C'sink holes as per Dwg D407-667-145. Allow rivet to sit below surface to compensate for paint.

9-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D407-667-145

W

14.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

15.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Process Sheet

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Drawing Name: 407 FWD X-TUBE

Job Number: 37005

Part Number: D407667105

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

OUTSIDE SERVICE

OUTSIDE SERVICES



Comment: Sub-Contracting OUTSIDE SERVICES
Liquid Penetrant Inspection as per QSI 038Or
Issue P/O: _____ LPI as per ASTM 1417
Level 2 Attach copy of NDT results to work order

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Inspect for transit damage
Ensure copy of NDT results attached to work order.

19.0

QC6

DIMENSIONAL CHECK



Comment: Inspect for damage & ensure results are as per Dwg D206-667-103

20.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

1-Prime inside and outside crosstube as per QSI 005 4.2

2-Paint outside crosstube with White Imron as per QSI 005 4.2

21.0

QC14

INSPECT SPRAY PAINT



Comment: Inspect Spray Paint
Wrap in plastic bag to protect from scratches

22.0

D2856400

Abrasion Strip



Comment: Qty.: 1.2138 f(s)/Unit Total : 1.2138 f(s)
Pick:
Qty Part number Description Batch
2 D2856-400(Cut to 6.94") Abrasion Strip

23.0

D2873043

Nut Plate Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick:
Qty Part number Description Batch
2 D2873-043 Nut Plate

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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QA: N/C Closed: _____ Date: _____

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Drawing Name: 407 FWD X-TUBE

Job Number: 37005

Part Number: D407667105

Job Number:



Seq. #:

Machine Or Operation:

Description :

24.0

D2873045

Nut Plate Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2873-045 Nut Plate

25.0

D28911

Support 2.25 dia



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2891-1 Support

26.0

MS20601AD4W10

RIVET



Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)

Pick:

Qty Part number Description Batch

14 MS20601AD4W10 Rivet

27.0

MS2192020

Clamp (per MIL-DTL-8783C)



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part number Description Batch

4 MS21920-20 Clamp

28.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install abrasion strips as per QSI 035 using DT8579. Note: (3) top holes should be facing up.

2-Install supports and clamps as per Dwg D407-667-145. Torque clamps to 80-100 in lb

3-Install nut plates as per Dwg D407-667-145. Touch-up rivet heads with Imron paint.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 407 FWD X-TUBE

Job Number: 37005

Part Number: D407667105

Job Number:



Seq. #:

Machine Or Operation:

Description :

29.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

30.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

31.0

AN532A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: _____

32.0

MS21042L5

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Batch: _____

33.0

AN510A

Bolt



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Batch: _____

34.0

AN530A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:Packing Kit

Qty Part number

Description Batch

4 AN5-30A

Bolt

35.0

AN960JD516

Washer



Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

Pick:Packing Kit

Qty Part number

Description Batch

18 AN960JD516

Washer

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 407 FWD X-TUBE

Job Number: 37005

Part Number: D407667105

Job Number:



Seq. #:

Machine Or Operation:

Description :

36.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

MAX

W

37.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D407-667-105

Location: _____

PPP Rev: _____

38.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

NEW KAN BAN System

D08104/02

Job Completion



W 08104/02

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	37005
Description: Crosstube Assembly	Part Number:	D407-667-145
Inspection Dwg: D407-667-145 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

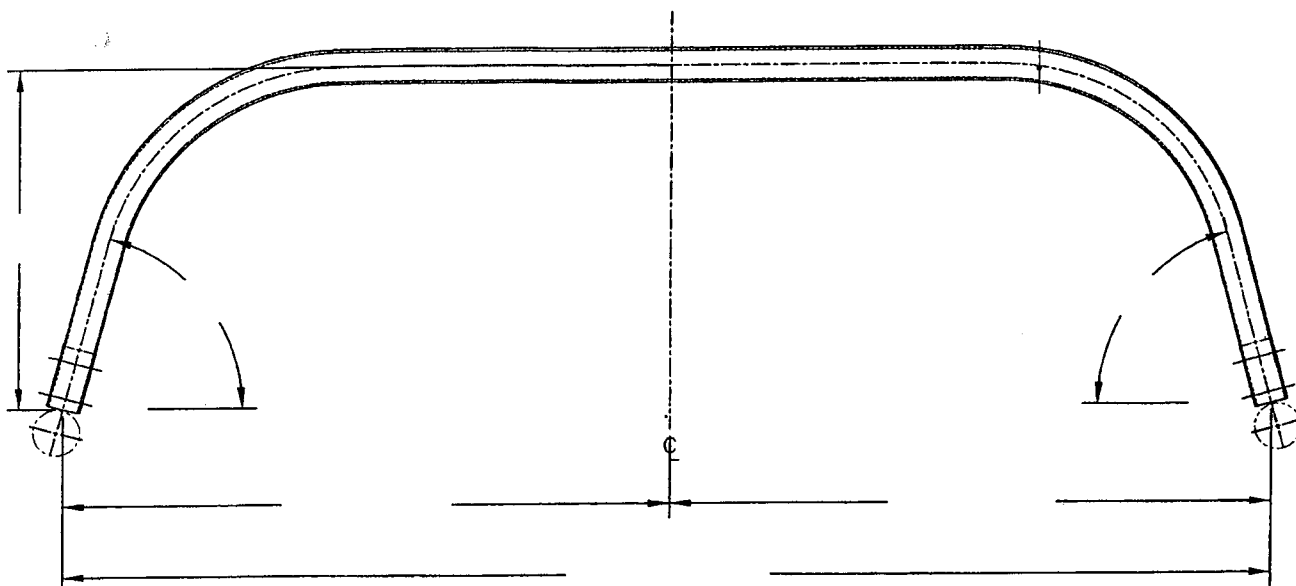
	Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	2.240	+0.005/-0.000	2.242	✓			
	1.865	+0.005/-0.000	1.869	✓			
	1.878	+0.005/-0.000	1.882	✓			
	1.970	+0.005/-0.000	1.974	✓			
	2.030	+0.005/-0.000	2.034	✓			
	2.165	+0.005/-0.000	2.168	✓			
	0.125	+/-0.010	.125	✓			
	R0.063	+/-0.010	.063	✓			
	R0.500	+/-0.010	.500	✓			
	R0.063	+/-0.010	.063	✓			
	4.438	+/-0.010	4.438	✓			
SIDE B	2.240	+0.005/-0.000	2.242	✓			
	1.865	+0.005/-0.000	1.869	✓			
	1.878	+0.005/-0.000	1.882	✓			
	1.970	+0.005/-0.000	1.974	✓			
	2.030	+0.005/-0.000	2.034	✓			
	2.165	+0.005/-0.000	2.169	✓			
	0.125	+/-0.010	.125	✓			
	R0.063	+/-0.010	.063	✓			
	R0.500	+/-0.010	.500	✓			
	R0.063	+/-0.010	.063	✓			
	4.438	+/-0.010	4.438	✓			
	113.20	+/-0.020	113.20	✓			

Measured by:	BE	Audited by:	gmh	Prototype Approval:	N/A
Date:	06.03.01	Date:	08/03/03	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.04.21	New Issue (P/O D407-667-105)	KJ/RF	
B	06.03.09	Dwg Rev updated	KJ/JLM	

DART AEROSPACE LTD		Work Order:	37005
Description: Crosstube High Fwd (407)		Part Number:	D407-667-105
Inspection Dwg: D407-667-145 Rev: B		Page 1 of 1	

Required Dimension	Min	Max
Height	23.48	23.60
1/2 Span	45.88	46.0
Angle	54	56
Total Span	91.76	92.0



Comments

QC15 Inspection	
Date	

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	<i>[Signature]</i>

DART

DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED DS	APPROVED DS	DRAWING NO. D407-667-145	REV. B SHEET 1 OF 3
DATE 05.07.26		TITLE CROSSTUBE ASS'Y (407 HIGH FWD)	SCALE NTS
A	02.05.08	NEW ISSUE	
B	05.07.26	ADD HOLES AND NUT PLATES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	

RELEASED
05.07.26UNDER REVIEW
06.08.10
re-draw detail
PH
07.06.19

Qty	Part Number	Description
X	D407-667-145	CROSSTUBE ASSEMBLY (407 HIGH FWD)
1	D6010-115	CROSSTUBE
2	D2856-400-694	ABRASION STRIP
2	D2873-043	NUT PLATE
2	D2873-045	NUT PLATE
2	D2891-1	SUPPORT
14	MS20601AD4W10	RIVET (OR NAS9302B-4-10)
4	MS21920-20	CLAMP

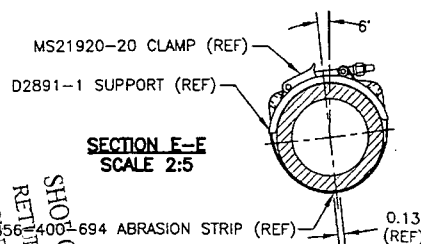
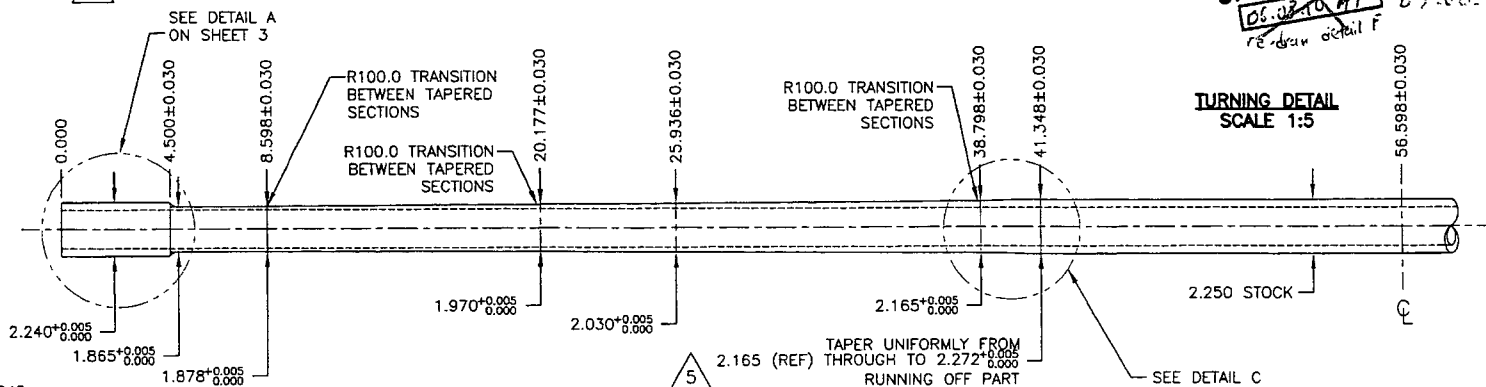
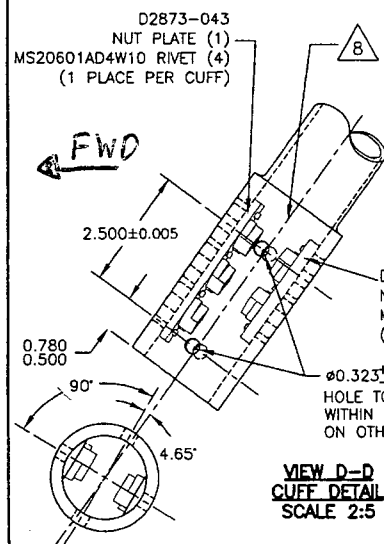
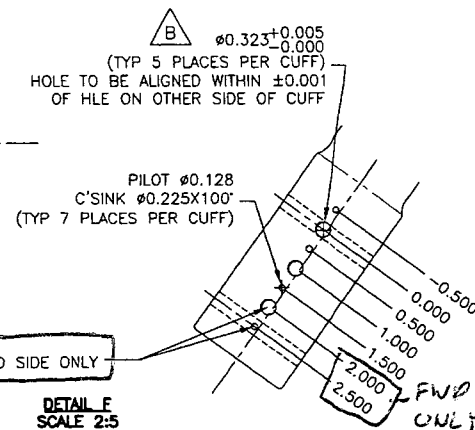
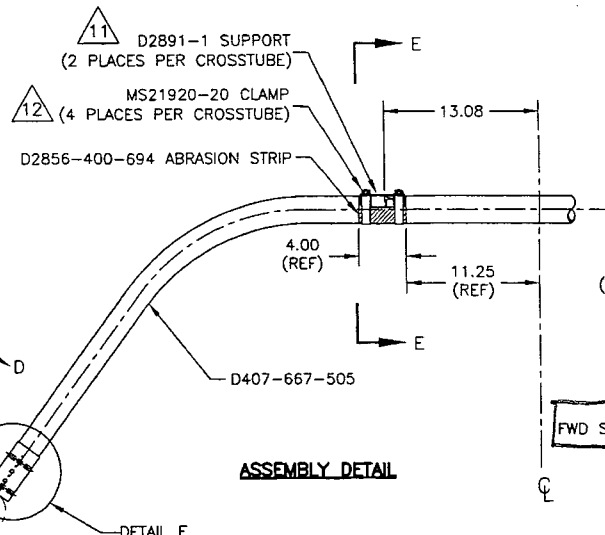
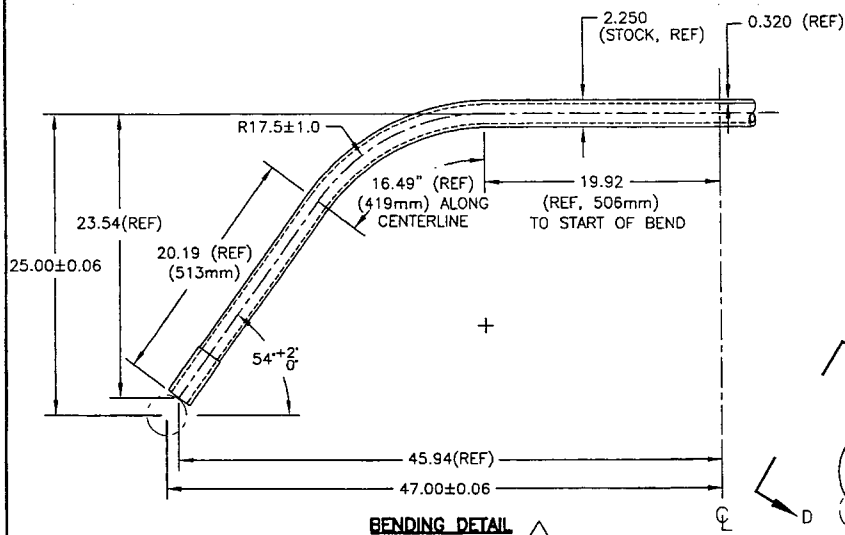
GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 2) MATERIAL: MANUFACTURED FROM D6010-115
FINISHED LENGTH = 113.20±0.020
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE.
- 5) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 6) BEND PROGRESSIVELY WITH A MINIMUM OF 6 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 7) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 8) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 9) INSTALL D2856-400-694 ABRASION STRIP WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D2891-1 SUPPORT, PER QSI 035.
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 11) SEAL EDGES OF SUPPORTS AND ABRASION STRIP USING SIKAFLEX-241/291 SEALANT (OPTIONAL).
- 12) TORQUE CLAMPS 80 TO 100 IN-LB.

SHOP COPY
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 37005

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UNDER REVIEW
05.07.10 PH
07.06.19
re-draw detail F

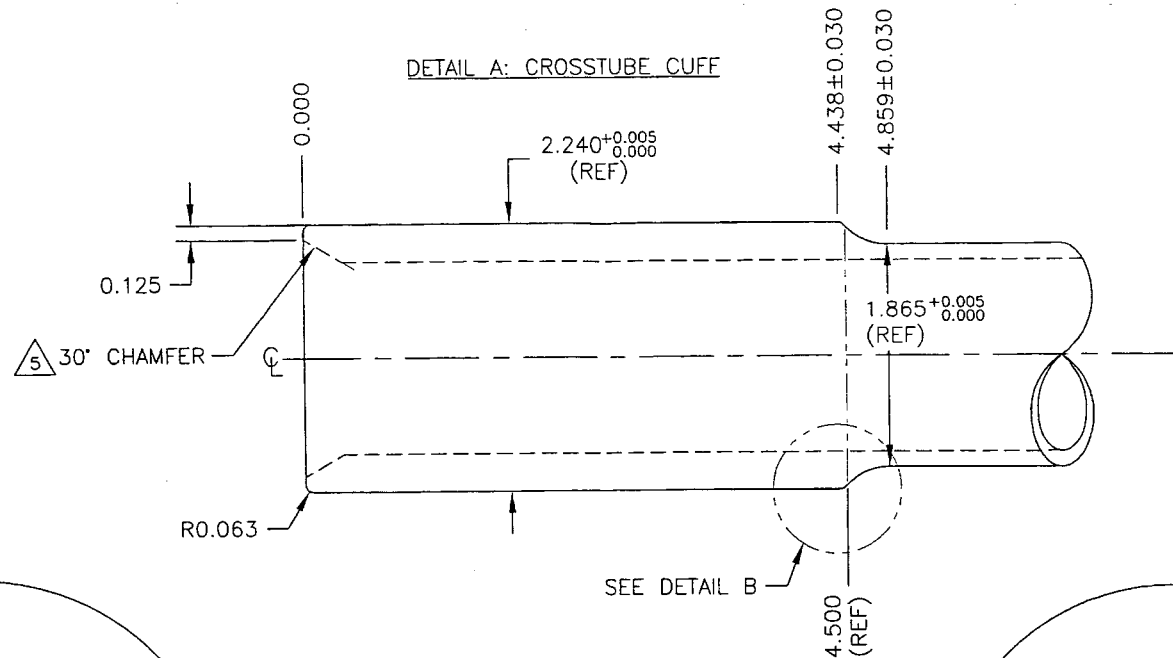
TURNING DETAIL
SCALE 1:5

RELEASED
05.07.10 PH

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THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		CHECKED # DS	APPROVED # DS	DRAWING NO. D407-667-145	SHEET 2 OF 3
DATE 05.07.26		TITLE CROSSTUBE ASS'Y (407 HIGH FWD)		SCALE 1:10	

NO. 37005
WORK ORDER
SUBJECT TO AMENDMENT
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ENGINEERING
RETURN TO
SHO COPY

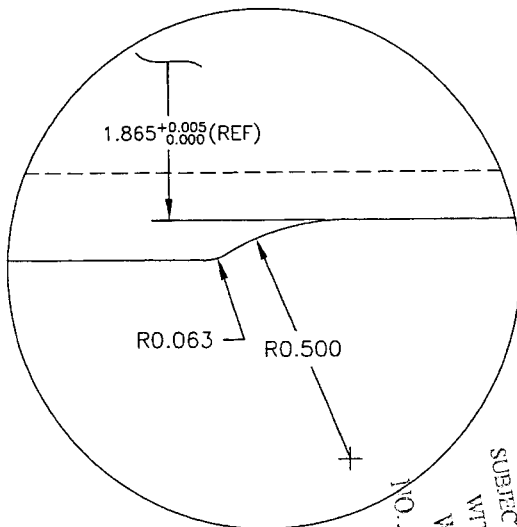
DETAIL A: CROSSTUBE CUFF



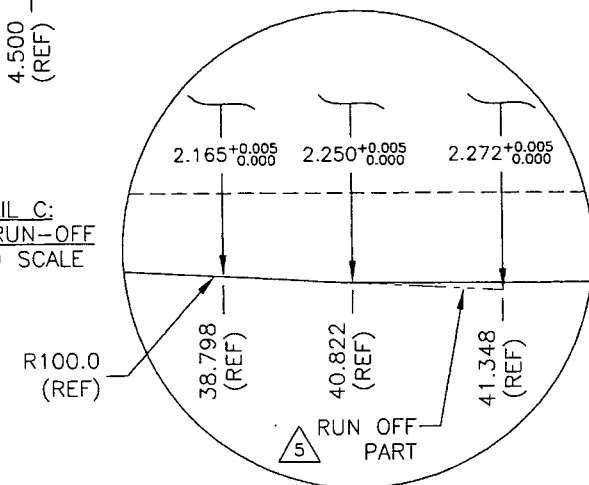
UNDER REVIEW PH
05-07-10 PH
Re-draw detail F 07.06.10

05-07-26

DETAIL B: CUFF TRANSITION SCALE 4:1



DETAIL C: TAPER RUN-OFF NOT TO SCALE



NO. 37005
WORK ORDER
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DESIGN	DRAWN BY	DART	DART AEROSPACE LTD. WARRICKSBURY, OXFORD, CANADA
PH	PH		
CHECKED # DS	APPROVED # DS	DRAWING NO. D407-667-145	REV. B SHEET 3 OF 3
DATE 05.07.26	TITLE CROSSTUBE ASS'Y (407 HIGH FWD)	SCALE 1:1	

